

Work Order ID 66135

Monday, February 07, 2011 10:59:00 AM

Page 1

Item ID: D3537-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearpad

Start Date: 2/8/2011 Start Qty: 40.00

Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 40.00

Customer:

Reference:

Run Start

Approvals: Process Plan: *MT*

Date: 11-02-07

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3537

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537 Dwg Rev: *C* Prog Rev: *C* 12-Deburr if necessary

DL 002

11-2-9

(48)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11-2-9

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

ml 11

02 08

(48)

Work Order ID 66135

Monday, February 07, 2011 10:59:00 AM

Page 2

Item ID: D3537-1

Accept



Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 2/8/2011 Start Qty: 40.00

Required Date: 2/22/2011 Req'd Qty: 40.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1

SB 11/02/10

4/8

140



Large Fab

Large Fab

0.00

Memo

0.00

Large Fab

Qty Description Batch: A/R 2059B Hardcoat
11-7-09 1-Weld as per Dwg D3537 using Jig DT 8210 2-Remove any weld that penetrated through Wearpad if necessary

EL 11-5-2 X13

150



QC

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

Quality Control

8 ulorlor

Work Order ID 66135

Monday, February 07, 2011 10:59:00 AM

Page 3

Item ID: D3537-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 2/8/2011 Start Qty: 40.00

Required Date: 2/22/2011 Req'd Qty: 40.00



Cust Item ID:

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

S. 11/05/02

(X13)

Quality Control

170

Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3

0.00



Powdercoat

MU5128

Memo

0.00

Powder Coating

START TIME:

11:46

OVEN TEMPERATURE:

350 FINISH TIME:

10:10

13 BK 11-5-3

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

13 & MU 11/05/02

Work Order ID 66135

Monday, February 07, 2011 10:59:00 AM



Page 4

Item ID: D3537-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 2/8/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location:

FD-17

0.00



Packaging

Memo

0.00

Packaging

13 BR 11-5-3.

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/05/04

11-05-4

(13)

Picklist Print

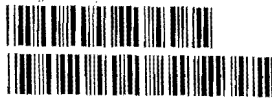
Monday, February 07, 2011 10:58:57 AM

Page 1

Work Order ID: 66135

Parent Item: D3537-1

Parent Item Name: Wearpad



Start Date: 2/8/2011

Required Date: 2/22/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	222.2800	0.106	4.463158		S.1	

M304S16GA



304/316 Sheet .063



11-2-9

Location

Loc Qty

Loc Code

MAT

222.28

111323

0

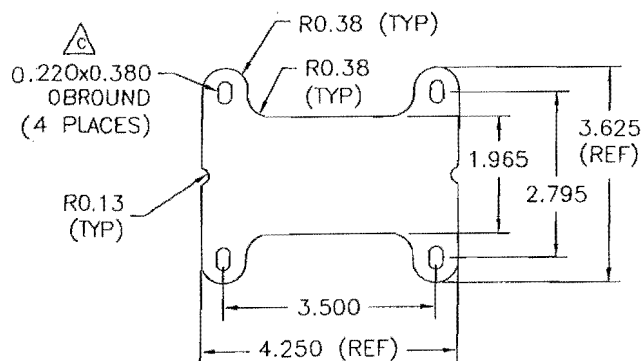
116623

222.28

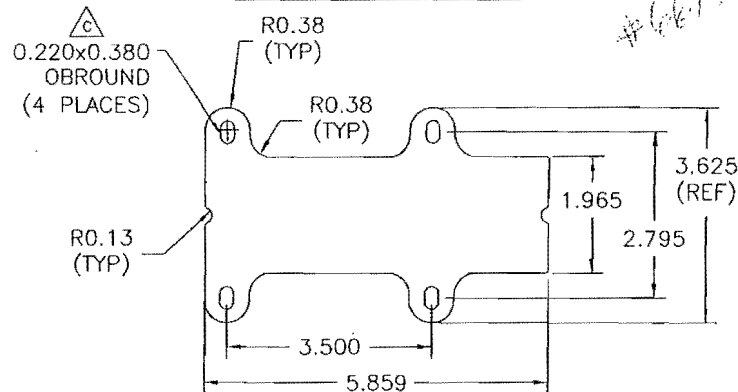
116623

48

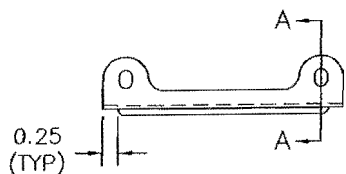
D3537-1F FLAT PATTERN



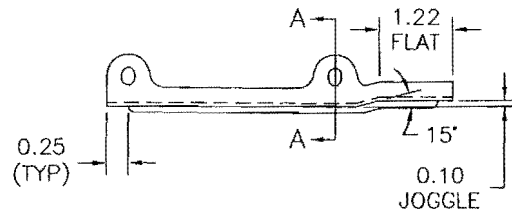
D3537-3F FLAT PATTERN



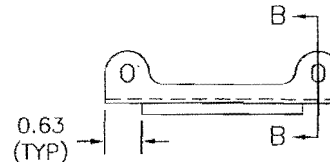
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



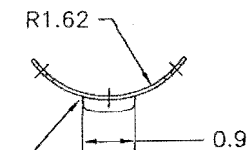
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)

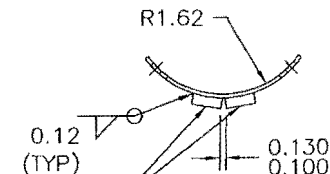


SECTION A-A



APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

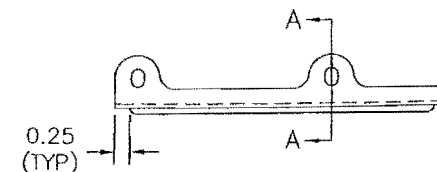
SECTION B-B



D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

RELEASED
07-05-03 AH
REV EGN
962

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

COPYRIGHT © 2006 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
SHEET 1 OF 1		SCALE 1:2

DART DART AEROSPACE USA, INC.
PORT HADLOCK, MA